



Dart Aerospace Ltd.
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RBT18603
Job Sheet 179597



508

Part No: RBT18603

Job Qty: 2 ea

Part Name: Tail Rotor Feathering Bearing Removal Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 9/6/18

Created By: Logan David

Type: SOLD

Description:

Note: RBT18603 REV:H IPP REV:A 18.02.06 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		9/6/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	2 pcs		9/6/18	0.00	0.50	Small Fab-3		MLC
120	QC	2 pcs		9/6/18	0.00	0.00	QC5		MLC
130	Packaging	2 pcs		9/6/18	0.00	0.00	Packaging3-1		MLC
140	QC21-SA	2 Ea		9/6/18	0.00	0.00	QC21		MLC

Part Op
Descriptions: 110 - 1-Assemble as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90692A723	Spring Pin	2 pcs (1 ea)	90-Start up Operation	5044109
NTA-815	Thrust Bearing	2 Ea (1 ea)	110-Small Fab	5036193
RBT18603-1	Handle	2 Ea (1 ea)	110-Small Fab	1x 5045453
RBT18603-3	Modified Rod	2 Ea (1 ea)	110-Small Fab	5116006
RBT18603-5	Cup	2 Ea (1 ea)	110-Small Fab	5116007
RBT18603-7	Foot	2 Ea (1 ea)	110-Small Fab	5115147
TRC-815	Needle Bearing Washer	4 Ea (2 ea)	110-Small Fab	5098898
				5088953

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	90692A723	2	246	0
110-Small Fab	NTA-815	2	18	0
	RBT18603-1	2	1	0
	RBT18603-3	2	0	0
	RBT18603-5	2	0	0
	RBT18603-7	2	0	0
	TRC-815	4	28	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

Container No: S117864

Part: FB18603

Job No: 179597

Serial No/Batch: S117864

Revision: H

Inspector:

Exp Date:

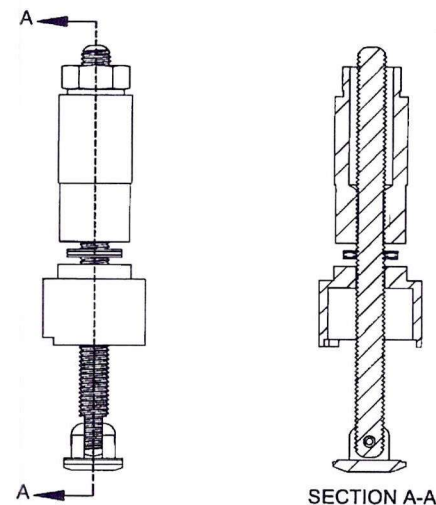
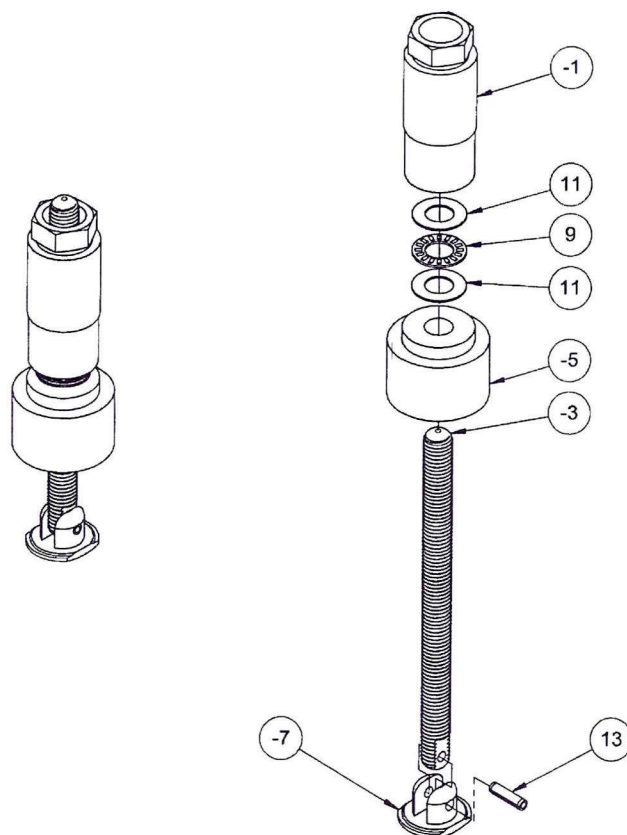
Instructions:

Date: 10/12/18

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CANADA 1 813 632-5200
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ITEM #	QTY	PART #	TITLE
-1	1	RBT18603-1	HANDLE
-3	1	RBT18603-3	MODIFIED ROD
-5	1	RBT18603-5	CUP
-7	1	RBT18603-7	FOOT
9	1	TORRINGTON #NTA-815	THRUST NEEDLE ROLLER BEARING
11	2	TORRINGTON #TRC-815	NEEDLE BEARING WASHER
13	1	McMaster#90692A723	SPRING PIN 3/16" x 3/4" LG.

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	HOLE ON DRAW BOLT ENLARGED TO ALLOW PROPER SWIVELING OF FOOT	-	6/1/2001	-	-
2	CHANGED CHAMFER TO FLAT RECESS, AND ADDED 274" CUT OUT TO -5 CUP	-	7/13/06	-	-
3	RECESSED -7 LIP .03 DEEP x 1.12	-	7/17/06	-	-
4	DELETED HOLE IN TOP OF -3 DRAW BOLT AND CHANGED -3 BOTTOM HOLE FROM .199 DIA., CHANGED -7 FOOT HOLE FROM .188 DIA CHANGED TO NEW REV. LOG, TITLE BLOCK, & BOM. ALSO ADDED ASSEMBLY VIEW	-	1/28/08	WP	DW
5	CHANGED -3 MATERIAL TO B7, DIM .22 TO .270 AND DIM .25 TO .300 ALSO CHANGED -5 DIM .63 DIA. TO .75 DIA. AND DIM .28 TO .312	-	12/18/08	WP	DW
6	-5 ADDED ENGRAVE T/N, S/N, "MADE IN USA", CH'D -1 & -5 TO YELLOW ZINC	-	5/18/09	RJC	RW
6A	DELETED NOTE, ADDED P/N FOR -3 PER R.W	-	3/15/12	RJC	RW
7	BROKE OUT INTO INDIVIDUAL SHEETS, -1 CH'D DIM WAS DRILL .72 DIA x 2 DEEP IS .75 DIA. x 2 DEEP	-	6/26/13	BIM	GE
H	ITEM 13 PURCHASE INFORMATION ADDED, TEMPLATE UPDATED, ITEM 11 BEARING WASHER CHANGED FROM #TRA-815 TO TRC-815, ITEM -3 NAME CHANGED FOR MODIFIED ROD	17-811	18.1.8	VM	ML



SECTION A-A

NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) SPEC: N/A
 5) BREAK ALL SHARP EDGES: N/A
 6) IDENTIFICATION: N/A

RBT18603 TAIL ROTOR FEATHERING BEARING REMOVAL TOOL

		Hawkesbury, Ontario, Canada	
		TITLE	
TAIL ROTOR FEATHERING BEARING REMOVAL TOOL			
PART NO.		RBT18603	
TOOL NO.		RBT18603	
DESIGNED BY:		VM 1/8/2018	
DRAWN BY:		VM 01/08/2018	
CHECKED BY:		VM 01/08/2018	
MFG REVIEW BY:		DD 01/08/2018	
APPROVED BY:		ML 01/09/2018	
INITIALS AND DATE		SCALE: NTS	
TOLERANCES:		SHEET 1 OF 5	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING		FRACTIONS 1/8	
XX ± .005		ANGLES ± .5°	
XX ± .01		SURFACE	
X ± .1		ROUGHNESS 125	
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